



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBH5610-705-40101-PO
Job Sheet 183671



Part No: RBH5610-705-40101-PO

Job Qty: 1 ea

Part Name: Inspection Fixture Fan Assembly Trans & Coupling



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/24/18

Job Tracking No:

Due Date: 12/3/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBH5610-705-40101 Rev. 3 IPP Rev. A 18.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	12/3/18	12/3/18	0.00	0.00	Purchasing		DEC 03 2018
110	Packaging	1 pcs	12/3/18	12/3/18	0.00	0.00	Packaging2		DEC 03 2018
120	QC	1 pcs	12/3/18	12/3/18	0.00	0.00	QC6		DEC 03 2018
130	Small Fab	1 pcs	12/3/18	12/3/18	0.00	0.20	Small Fab-6		DEC 03 2018
140	QC	1 pcs	12/3/18	12/3/18	0.00	0.00	QC5		DEC 05 2018
145	DC	1 pcs	12/3/18	12/3/18	0.00	0.00	DC		DEC 05 2018
150	Packaging	1 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3		DEC 05 2018
160	QC21-FG	1 Ea	12/3/18	12/3/18	0.00	0.00	QC21		DEC 05 2018

Part Op 100 - Issue PO to METEC P/O: 041119 MANUFACTURE RBH5610-705-40101 AS PER DWG - Certificate of
Descriptions: conformity is required
130 - Pack case
145 - Print and cut out RBH5610-705-40101-27 instruction card and put in case. ***NOTE*** User red paper as per DWG.
Found in FS1/Eugene Reference/Supplier Cad Data.

Set 24. 2018 x1 Pn h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBH5610-705-40101P	Inspection Fixture Fan Assembly Trans & Coupling	1 Ea (1 ea)	100-Purchasing	5134049
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	130-Small Fab	5096400

151 F
154

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBH5610-705-40101P	1	0	0
130-Small Fab	10164	1	8	0



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
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Container No: S134050



Part: RBH5610-705-40101

Job No: 183671

Serial No/Batch: S134050

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 12/03/18

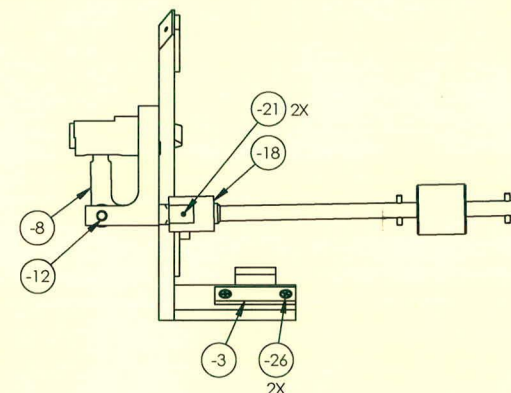
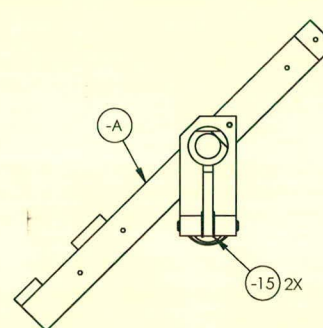
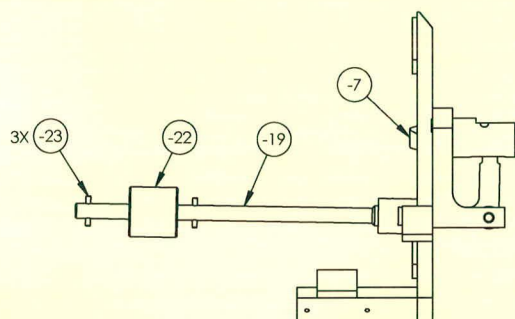
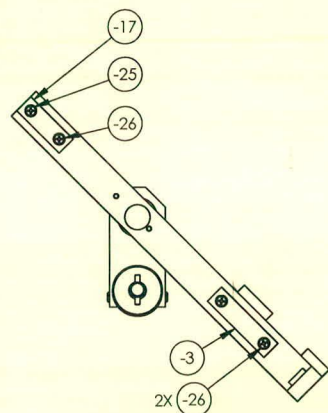
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ld not be found.

Plex 9/24/18 10:46 AM dart.Lussier.Patrick

100-10-100
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88
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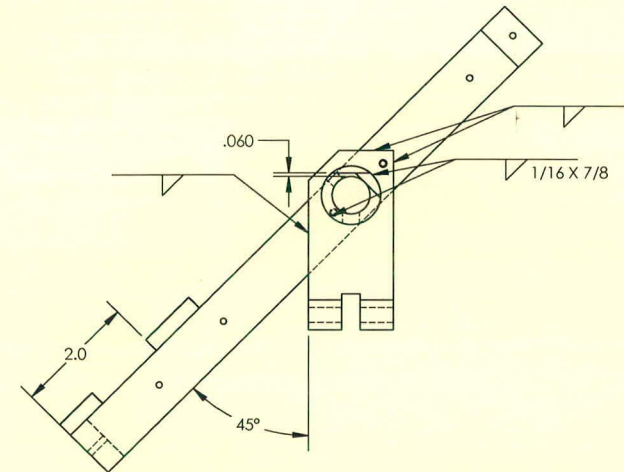
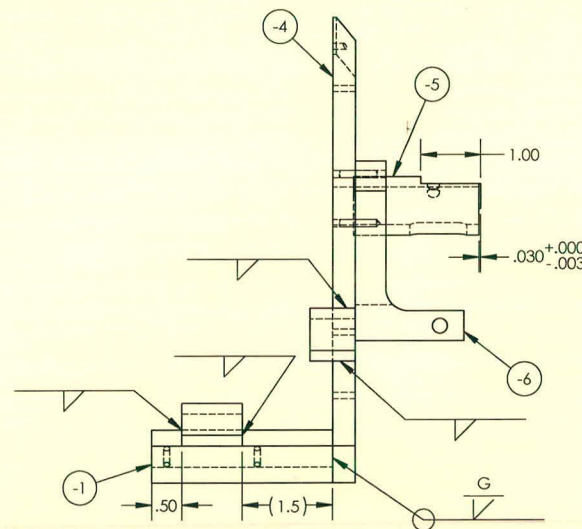
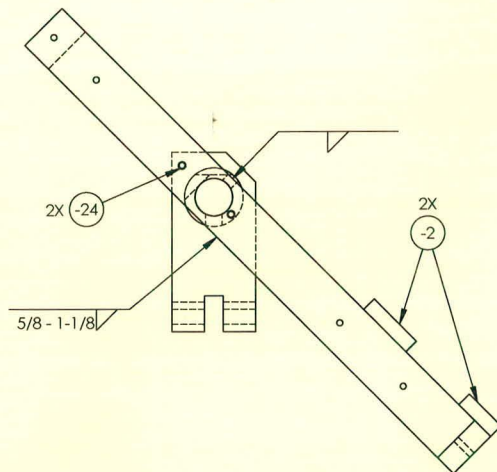
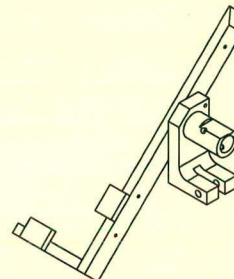
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
	X		-A	1	WELDMENT			2
	1		-1		LEG	A36/1018/1020 HR		3
	2		-2		PAD	A36/1018/1020 HR		4
			-3	2	PLATE	01		5
	1		-4		BAR	A36/1018/1020 HR		6
	1		-5		SLEEVE	A36/1018/1020 HR		7
	1		-6		LEG	HR ANGLE		8
			-7	1	PIN	01		9
			-8	1	LEVER	01		10
		B/O	-12	1	DOWEL PIN	STEEL	Ø1/4 X 1-1/2 (MCMASTER-CARR #98381A546)	1
		B/O	-15	2	FLAT WASHER	BRASS	Ø1/4 I.D. X 9/16 O.D. (MCMASTER-CARR #92916A365)	1
			-17	1	SMALL PLATE	01		11
			-18	1	SMALL SLEEVE	6061		12
			-19	1	LONG PIN	6061		13
		B/O	-21	2	BALL SPRING PLUNGER	STEEL	5-40 X 1/4 (MCMASTER-CARR #3408A66)	1
			-22	1	WEIGHT	A36/1018/1020 HR		14
		B/O	-23	3	DOWEL PIN	STEEL	Ø1/8 X 3/4 (MCMASTER-CARR #98381A473)	1
	2		-24		DOWEL PIN	STEEL	Ø1/8 X 5/8 (MCMASTER-CARR #98381A472)	2
		B/O	-25	1	FLAT HEAD MACHINE SCREW	STEEL	5-40 X 1/4 (MSC #40914814)	1
		B/O	-26	5	FLAT HEAD MACHINE SCREW	STEEL	5-40 X 3/8 (MSC #09173329)	1
			-27	1	INSTRUCTION SHEET	RED CONSTRUCTION PAPER	4 X 4	15
		B/O	-28	1	CASE	PLASTIC	4 GUN PELICAN #10164	N/S
	ASSY							

	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWO NO. RBH5610-705-40101	REV 3
MAT'L GREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .X ± .01 ANGLES ± 5° .X ± .1 SURFACES ± .125 ✓
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPQS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015X 2. DIMENSIONAL LIMITS APPLY AFTER PLATING IN ACC. TO CHM AND TOL PER ASME Y14.5M-2009 USED ON MODEL MD500
SCALE 1:3	DATE 6/11/2012
SHEET 1 OF 15	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	15-0289	-A ADDED DIMS .50, (1.5), 2.0 TO LOCATE -2. CHD WELD CALLOUT WAS 1/16 X 50% 2 PLACES 180° APART IS 1/16 X 50% 2 PLACES, ADDED FILLET WELD AT -1 & -4, ADDED MISSING 2X -24.			9/3/2015	RJC	JAG
3	16-0067	-A DELETED 2.58 DIM, CHD WELD CALLOUT WAS FILLET WELD 1/16 X 50 2 PLACES IS FILLET WELD 1/16 X 7/8.			7/5/2016	RJC	JAG

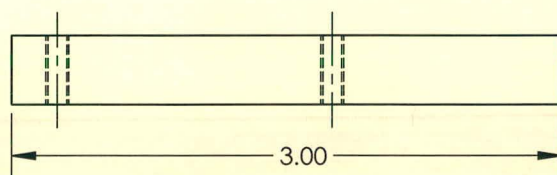
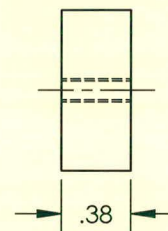
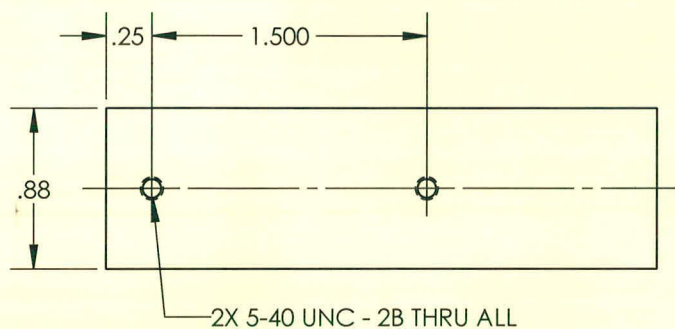
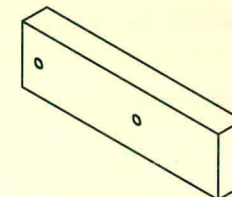


(-A)
WELDMENT

DART AEROSPACE	
TITLE: INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWG NO.: RBH5610-705-40101-A	REV 3
MAT'L: _____	UNLESS OTHERWISE SPECIFIED
HEAT TREAT: STRESS RELIEF	DIMENSIONS ARE IN INCHES
FINISH: BLACK OXIDE	.XXX ± .010 FRACTIONS ± 1/8
SPEC: QMSI-6.2.2 REV D	.XX ± .03 ANGLES ± 1°
DRAWN BY: CLOUGH	.X ± .1 SURFACES ± 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 X 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	MD500
SCALE: 1:2	DATE: 6/11/2012
	SHEET 2 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-1 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-1 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020.	7/5/2016	RJC	JAG

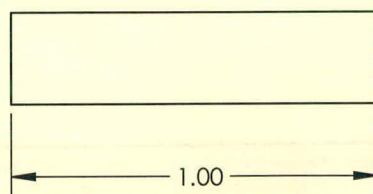
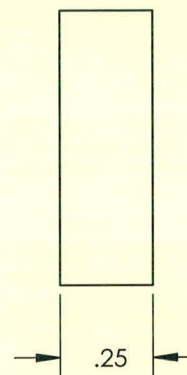
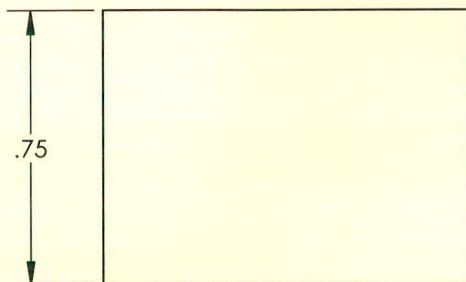
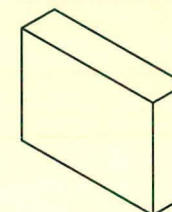


(-1)
LEG

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-1	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 56-60	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH SEE -A WELDMENT	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD500
APPROVED: GILBERT	
SCALE 1:1	DATE 6/11/2012 SHEET 3 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-2 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-2 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020.	7/5/2016	RJC	JAG



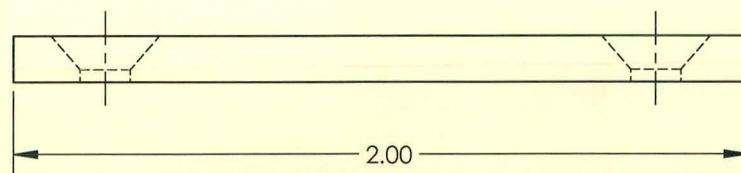
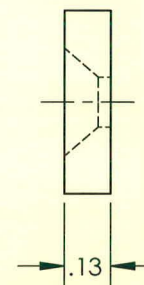
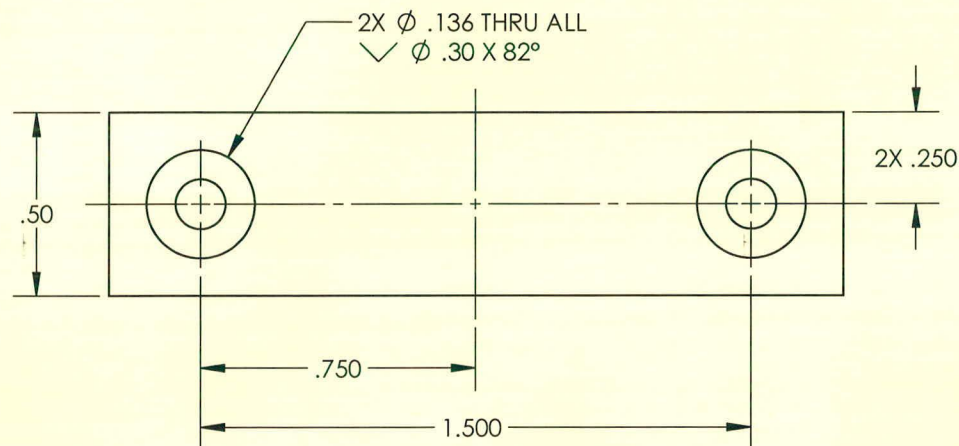
(-2)

PAD

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWG NO. RBH5610-705-40101-2	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -A WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD 500
SCALE 2:1	DATE 6/11/2012 SHEET 4 OF 15

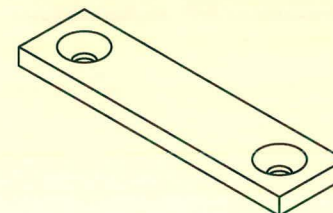
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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	15-0289	-3 CH'D DIM WAS 2X Ø.136 THRU ALL ✓ Ø.252 X 82° IS 2X Ø.136 THRU ALL ✓ Ø.30 X 82°. ADDED DIM 2X .250.			9/3/2015	RJC	JAG



(-3)

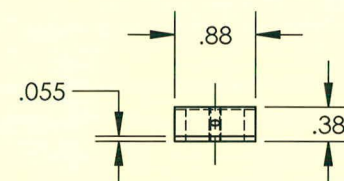
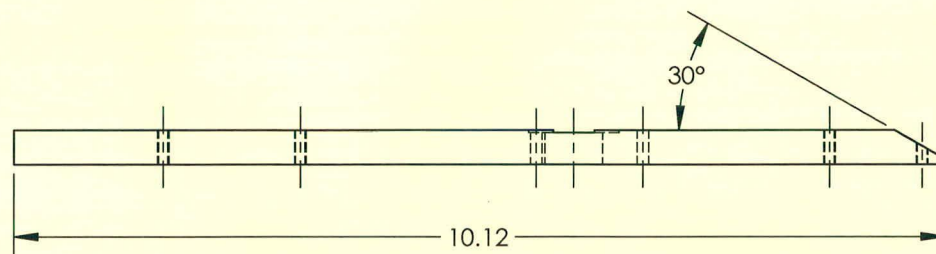
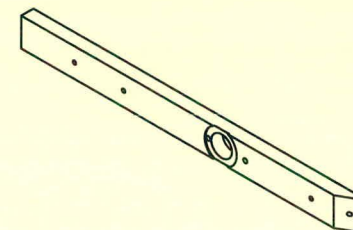
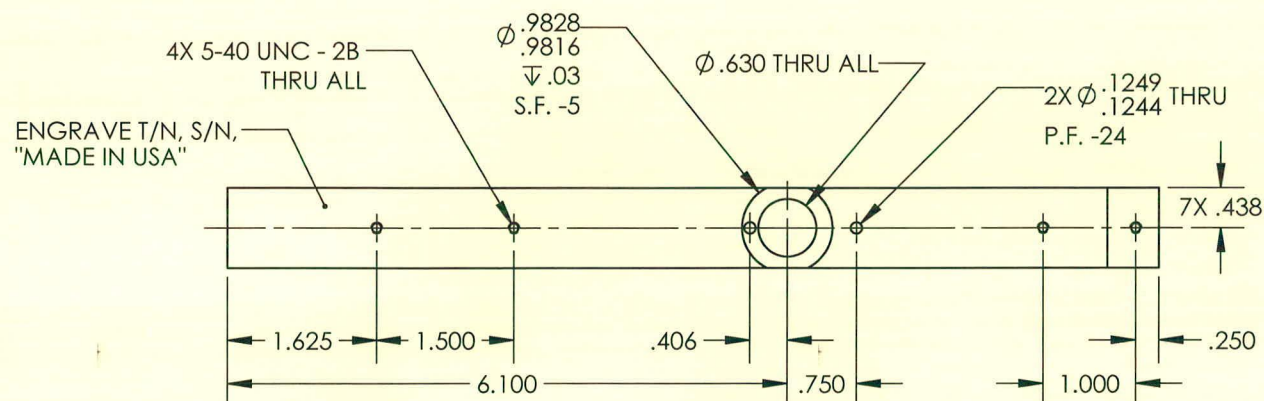
PLATE



DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-3	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT RC 56-60	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2 REV D	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	DATE 6/11/2012
	USED ON MODEL MD500
	SHEET 5 OF 15

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	15-0289	-4 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-4 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, ADDED ENGRAVE NOTE, ADDED DIM 7X .438, CH'D DIM WAS Ø1.000 ∇ .03 IS Ø.9828 - .9816 ∇ .03 S.F. -5.	7/5/2016	RJC	JAG

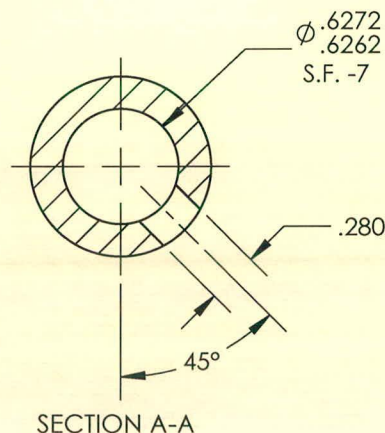
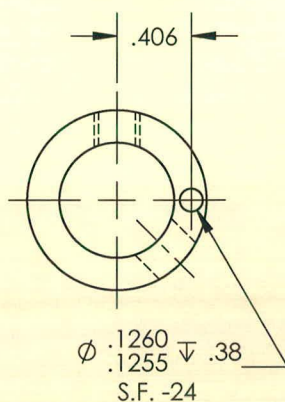
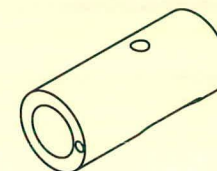
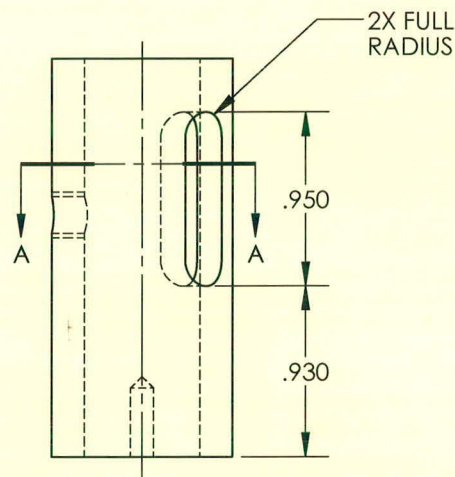
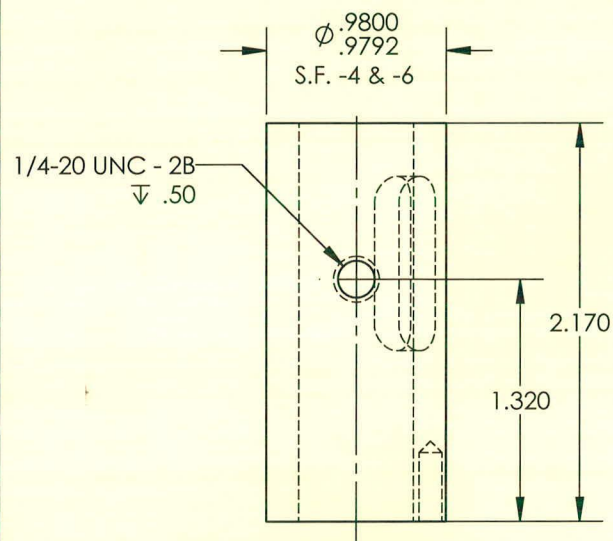


(-4)
BAR

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-4	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT SEE -A WELDMENT	DIMENSIONS ARE IN INCHES
FINISH SEE -A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:2	DATE 6/11/2012
SHEET 6 OF 15	

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	15-0289	-5 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-5 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, CH'D DIM WAS (Ø1.000) IS .9800 - .9792 S.F. -4 & -6, ADDED S.F. -7 TO Ø.6272 - .6262 DIM.	7/5/2016	RJC	JAG

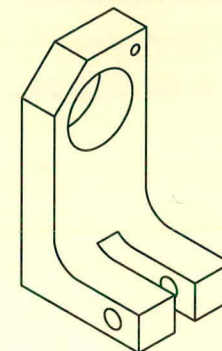
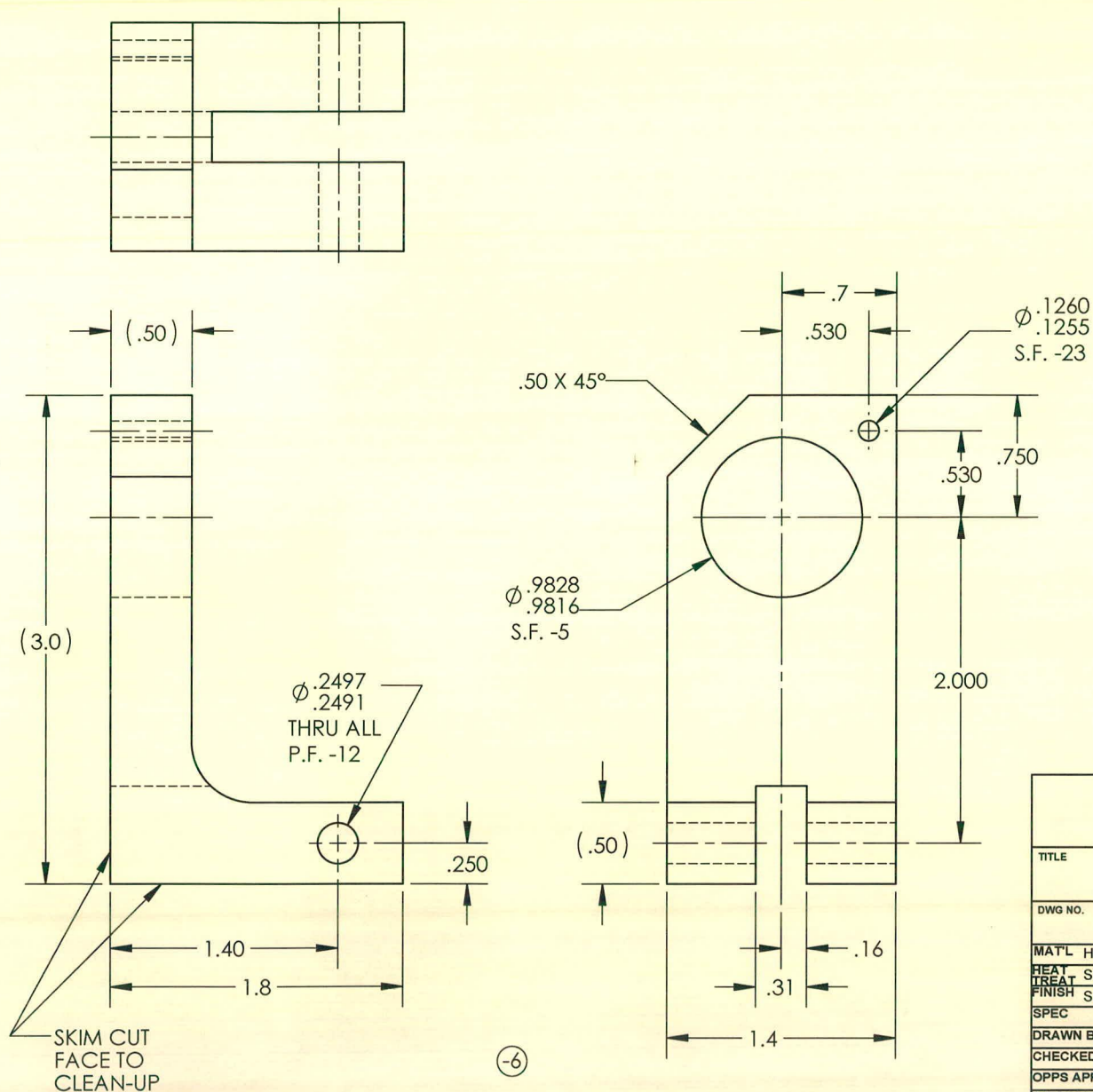


(-5)
SLEEVE

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-5	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XX ± .005 FRACTIONS ± 1/8
FINISH SEE -A WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012 SHEET 7 OF 15

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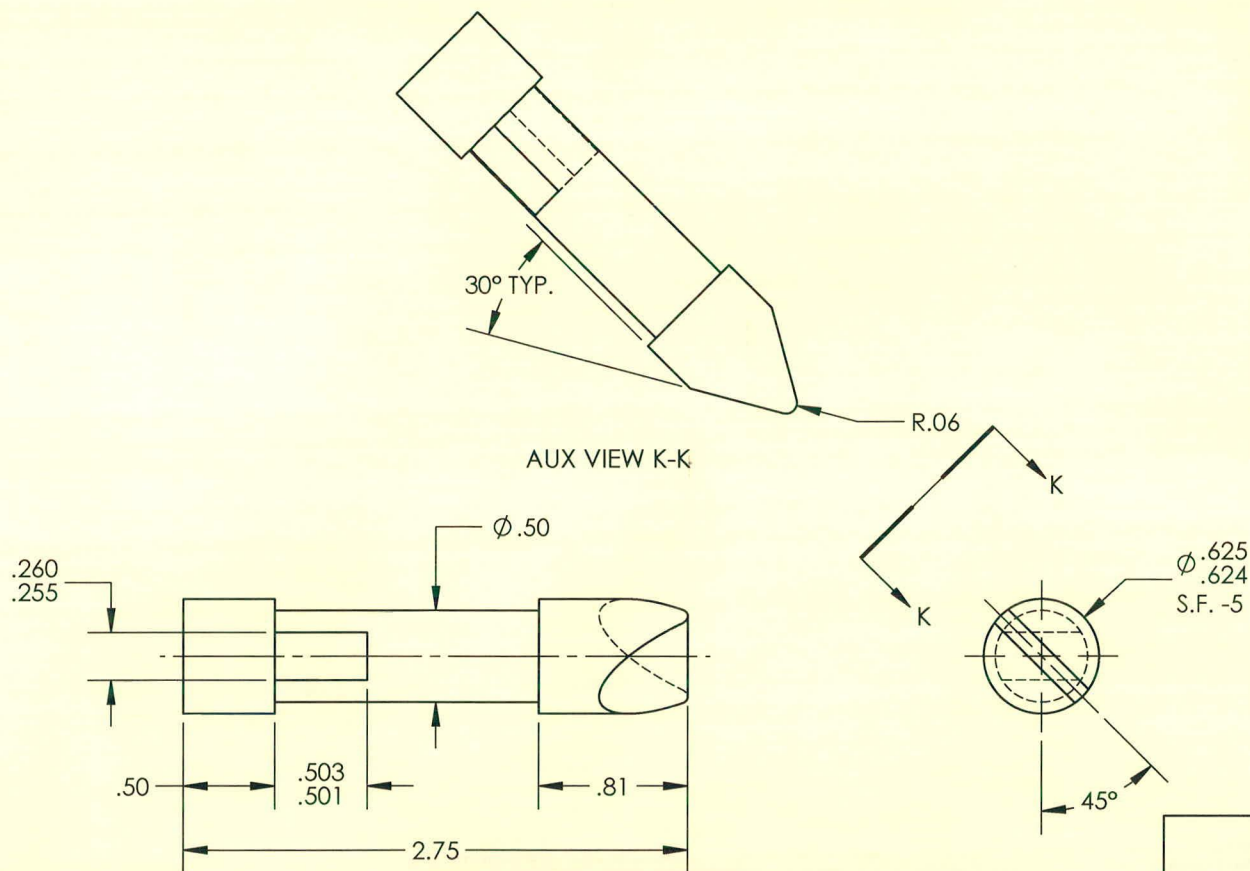
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0067	-6 CH'D DIM WAS 2X .50 IS 2X (.50), ADDED LEADER TO 2ND FACE TO SKIM CUT, CH'D DIM WAS Ø1.0012 - 1.0000 IS Ø.9828 - .9816 S.F. -.5.	7/5/2016	RJC	JAG



DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-6	REV 3
MAT'L HR ANGLE HEAT TREAT SEE -A WELDMENT FINISH SEE -A WELDMENT SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012
SHEET 8 OF 15	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	16-0067	-7 ADDED S.F. TO DIM Ø.625 - .624.		7/5/2016	RJC	JAG



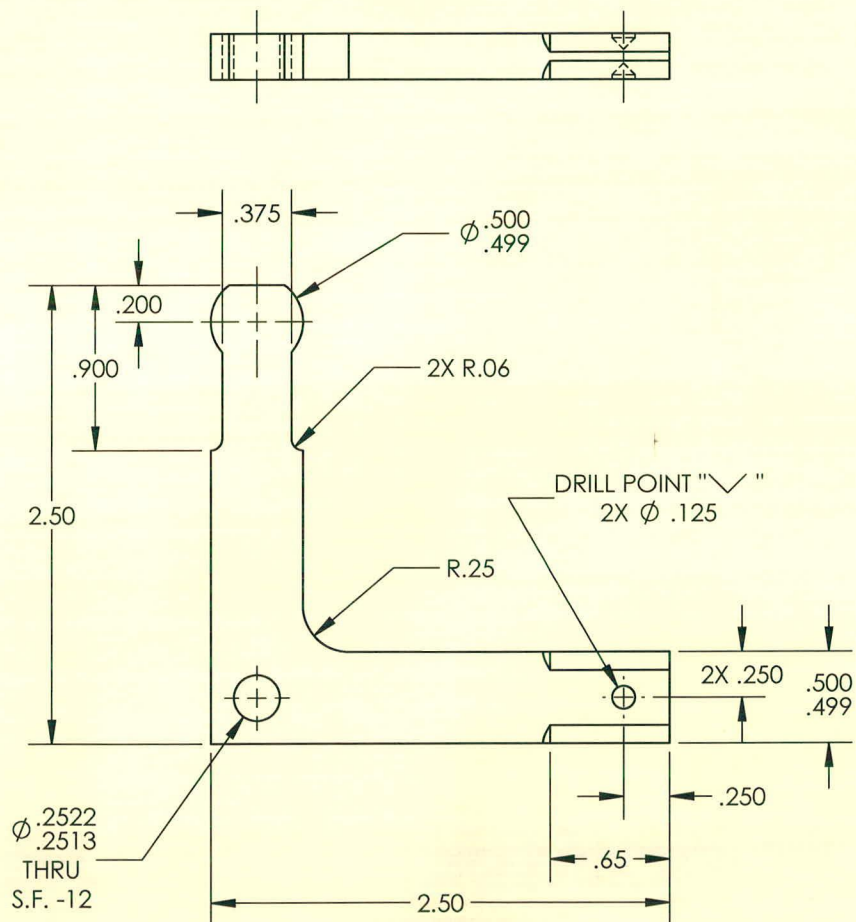
(-7)

PIN

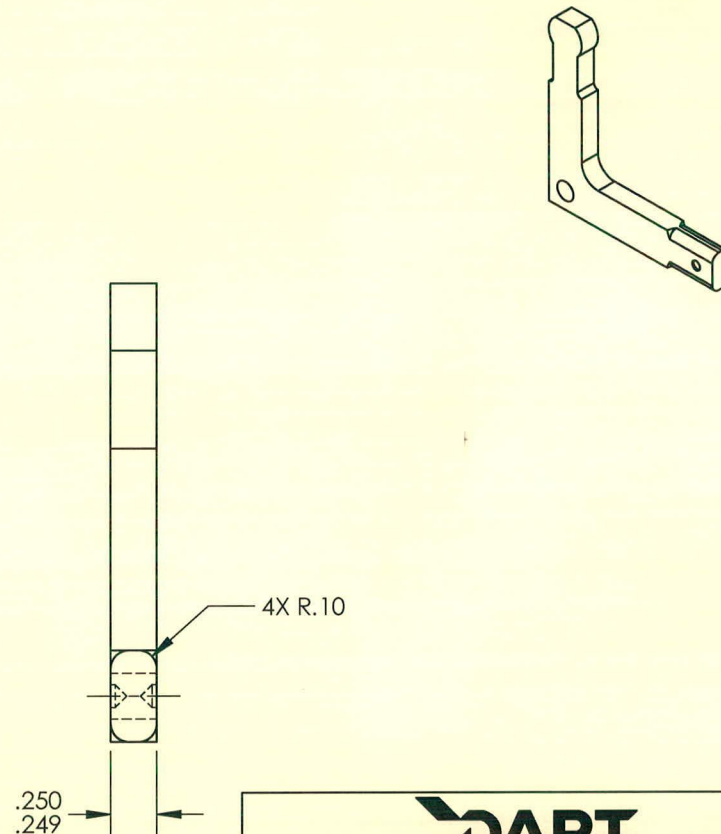
DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-7	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2 REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 6/11/2012
	USED ON MODEL MD500
	SHEET 9 OF 15

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	15-0289	-8 CH'D DIM WAS .600 IS .65.	9/3/2015	RJC	JAG



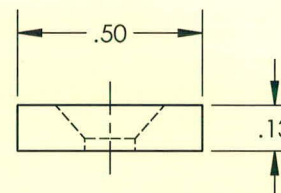
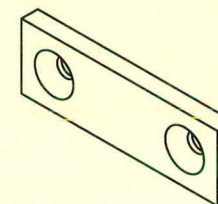
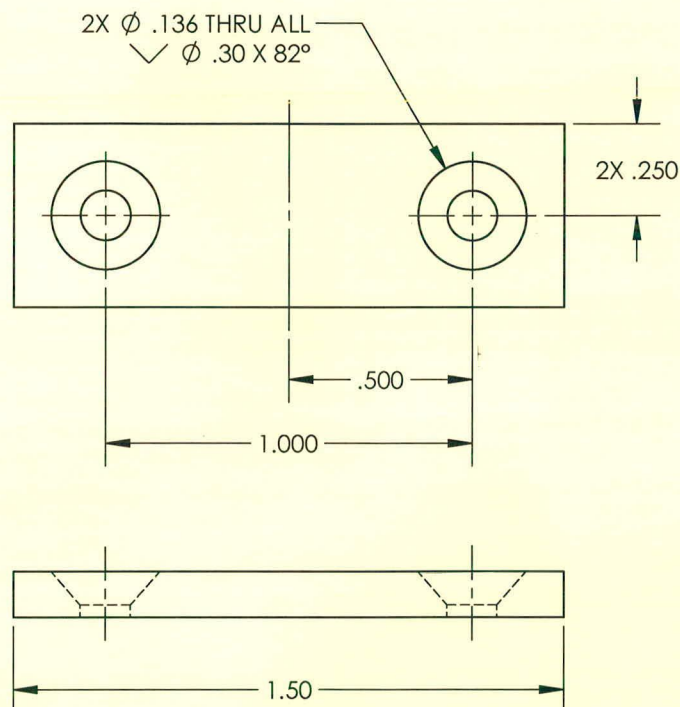
(-8)
LEVER



DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-8	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 56-60	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH BLACK OXIDE	.X ± .1 SURFACES = 125
SPEC QMSI-6.2.2 REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD500
APPROVED: GILBERT	
SCALE 1:1	DATE 6/11/2012 SHEET 10 OF 15

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REVISIONS					DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION					
2	15-0289	-17 CH'D DIM WAS 2X Ø.136 THRU ALL ∇ Ø.252 X 82° IS 2X Ø.136 THRU ALL ∇ Ø.30 X 82°.			9/3/2015	RJC	JAG



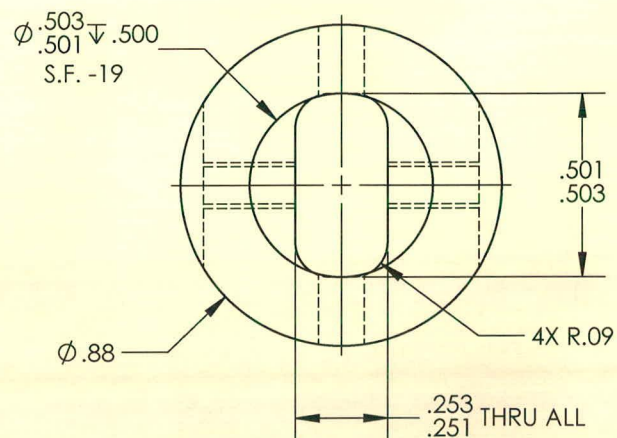
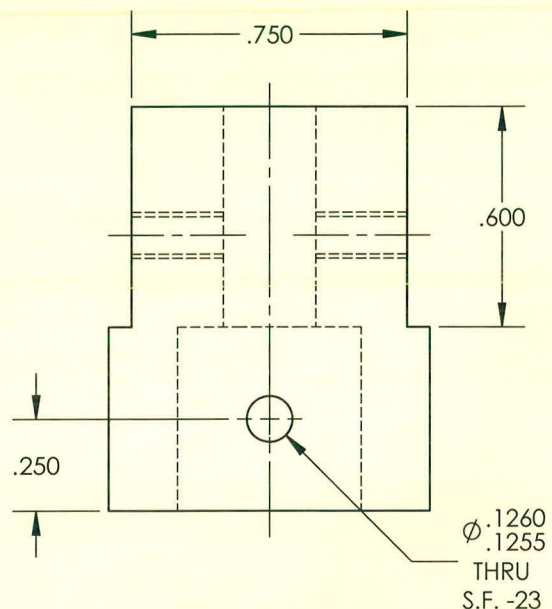
(-17)

SMALL PLATE

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-17	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 56-60	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2 REV D	.XX ± .01 ANGLES ± 5°
	X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 2:1	DATE 6/11/2012 SHEET 11 OF 15

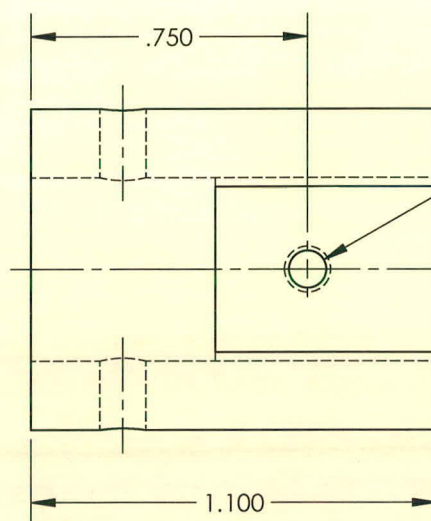
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	16-0067	-18 CH'D DIM'S WAS Ø.503-.501 THRU IS Ø.503-.501 ∇ .500, WAS .253-.251 ∇ .60 IS .253-.251 THRU ALL, ADDED S.F. -19 TO Ø.503-.501 ∇ .500 DIM.		7/5/2016	RJC	JAG

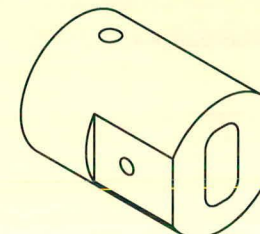


(-18)

SMALL SLEEVE



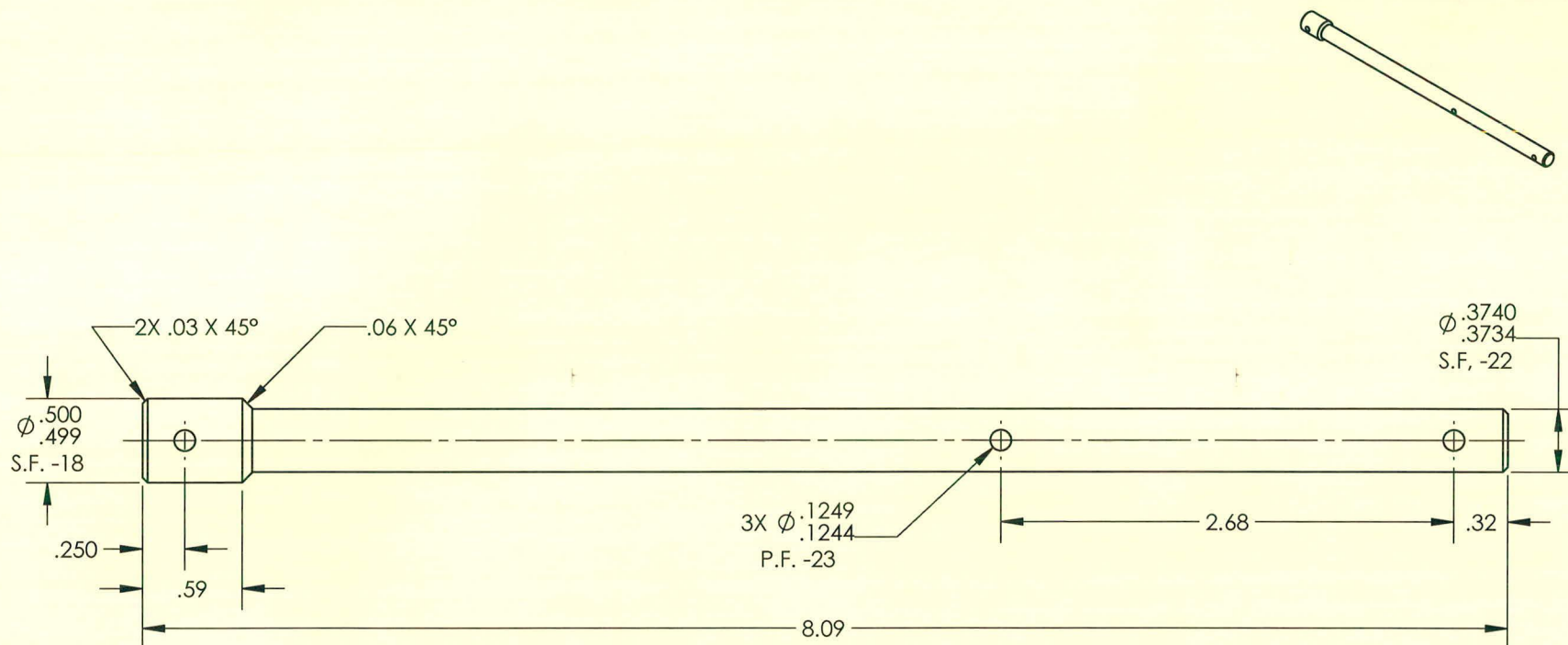
5-40 UNC - 2B THRU ALL



DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-18	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ANODIZE BLACK	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 2:1	DATE 6/11/2012 SHEET 12 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-19 CH'D DIM WAS 2X Ø.1249 - .1244 IS 3X Ø.1249 - .1244 P.F. -23, DELETED DIM 7.12, CH'D DIM WAS (2.68) IS 2.68, WAS .65 IS .59, ADDED DIMS 2X .03 X 45°, .06 X 45°, .32	9/3/2015	RJC	JAG
3	16-0067	-19 ADDED S.F. -18 TO Ø.500 - .499 DIM, ADDED S.F. -22 TO Ø.3740 - .3734 DIM, ADDED P.F. TO 3X Ø.1249 - .1244 DIM.	7/5/2016	RJC	JAG

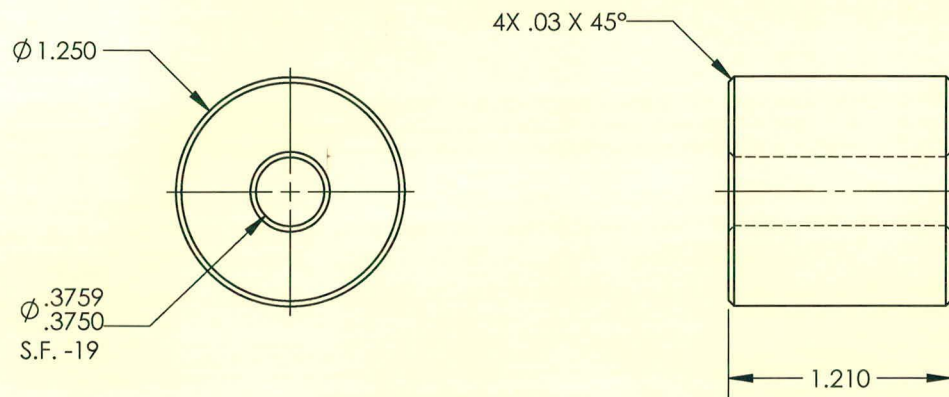
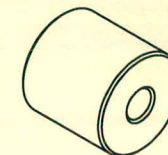


(-19)
LONG PIN

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-19	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ANODIZE BLACK	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012 SHEET 13 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-22 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-22 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, ADDED S.F. -19 TO Ø.3759 - .3750 DIM.	7/5/2016	RJC	JAG



(-22)

WEIGHT

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-22	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .5°
SPEC QMSI-6.2.2 REV D	X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012 SHEET 14 OF 15

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

RBH5610-705-40101

TOOL FUNCTION

TO CHECK FAN BELT DEFLECTION AT .17 TO .20 AND LOAD AS FOLLOWS:

<u>FAN PART No.</u>	<u>LOAD</u>
369H5610-705	1.00 – 1.75 LBS.
369D25610	1.75 – 2.00 LBS.

OPERATING INSTRUCTIONS

1. REMOVE WEIGHTED ARM FROM TOOL (FOR 369H5610-705 ONLY).
2. INSTALL TOOL TO REST AGAINST BELT AT SMALL PULLEY & LARGE PULLEY.
3. INSTALL WEIGHTED ARM ON TOOL (FOR 369H5610-705 ONLY).

NOTE: CHECKING THE TENSION OF THE 369D25610 FAN ASSEMBLY

DOES NOT REQUIRE THE WEIGHTED ARM TO BE REMOVED.

4. POSITION WEIGHT BETWEEN PIN STOPS AS REQUIRED TO PLACE FLUSH PIN BETWEEN STEPS. FOR TENSION TO BE ACCEPTABLE, FLUSH PIN MUST FALL BETWEEN STEPS.

NOTE:
INSTRUCTION CARD ON 4 X 4 RED PAPER.

(-28)

INSTRUCTION SHEET

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-27	REV 3
MAT'L RED CONSTRUCTION PAPER	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD500
APPROVED: GILBERT	
SCALE 1:1	DATE 6/18/2012 SHEET 15 OF 15



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041119**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041119
PO Date: 9/24/18
Due Date: 12/3/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183671	RBH5610-705-40101P			Inspection Fixture Fan Assembly Trans & Coupling	Firmed	-	12/3/18	1 Ea	0 Ea	1 Ea	\$1,750.00/Ea	\$1,750.00

1X

DEC 03 2018

DAS
68
9-89

Grand Total: \$1,750.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 9/24/18 10:50 AM dart.Lussier.Patrick

24
33
26



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24331
Shipment Date: 03-Dec-2018
Ship Via: Pick up at METEC
Order Number: 3047
Order Date: 09/24/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041119 ✓
Terms: Net 60 Days

Quantity								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
1	1	1 ✓	0	0	EA	DART-RBH5610-705-40101P Inspection Fixture Fan Assembly Trans. & Coupling	3	3047-01

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1	RBH5610-705-40101P	Inspection Fixture Fan Assembly Trans. & Coupling	3	PO041119
No deviations for this part				
Material supplied by METEC				

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Théoret

DAS
68
9-89

Vankleek Hill, December 3, 2018

